

Work Order ID 108295

Tuesday, October 15, 2013 9:03:32 AM

D 2616-1
B 108295

108295

Ship ASAP Page 1

Item ID: D2616-1

Revision ID:

Item Name: Mounting Lug

Start Date: 10/15/2013 Start Qty: 20.00

Required Date: 10/18/2013 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MCF

Date: 13-10-15 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2616

Rev E

100

0.00

100

Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 2,000" long +0.030" -0.000"

JFC 2013-10-15

22 0

110

0.00

110

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D2616-1 & DWG D2616 2-Tumble & Deburr

JFC 2013-10-15

22 0

120

0.00

120

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

JFC 2013-10-15

22 0

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SHIP TODAY 17/10

Page 2

Item ID: D2616-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 10/15/2013 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 10/18/2013 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		only 13/10/17		22	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				22		13/10/17	
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M125028 Memo Note:Mask large hole TEMPERATURE: 370° FINISH TIME: 10:50 OVEN 11:20	0.00 0.00				22	0	13-10-17	

DAS
34
9-89

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SHIP TODAY
17/10

Page 3

Item ID: D2616-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 10/15/2013 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 10/18/2013 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				22x	/	all	13/10/17
170 *170* Small Fab Small Fab	Small Fab Memo 1-Coat bearing in light oil2-Press Bearing in D2616-13-Stake as per Dwg D2616 using DT8019 4- Touch up paint if required	0.00 0.00				20			FF 13-10-17
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				20			

DAS
27
9-89

13 10 17

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Page 4

Item ID: D2616-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 10/15/2013 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 10/18/2013 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.00							
Packaging	SHIP								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

13/14/17 (20)

MLJ 13-10-17

MF
13-10-17

Picklist Print

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Page 1

Work Order ID: 108295

Parent Item: D2616-1

Parent Item Name: Mounting Lug

Start Date: 10/15/2013

Required Date: 10/18/2013

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:C00.06.22Removed P/O for powder coatEC
IPP Rev:D 07-12-17 rev E as per dwg ECN 1069 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2611		Manufactured	No			100	Each	21.0000	1	20			
-------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Bearing

Location

Loc Qty

Loc Code

ST013

21

86264

1

86931

10

97458

10

M6061T6B1.000X02.000

Purchased

No

170

f

120.0002

0.1666

4

6061-T6 Bar 1.00 x 2.00

Location

Loc Qty

Loc Code

MAT003

120.0002

125258

0.0002

M126075

96

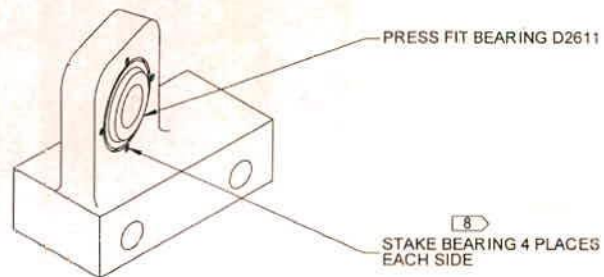
M126160

24

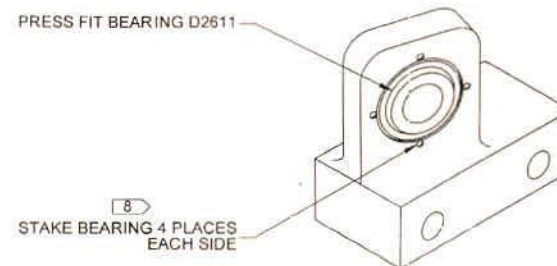
4

Jfc 2013-10-15

FF13-10-17



D2616-1 FWD MOUNT LUG



D2616-2 FWD MOUNT LUG

QTY -1	QTY -2	PART NUMBER	DESCRIPTION
X		D2616-1	FWD MOUNT LUG
	X	D2616-2	FWD MOUNT LUG
1	1	D2611	BEARING
1		D2616-1A	LUG
	1	D2616-2A	LUG

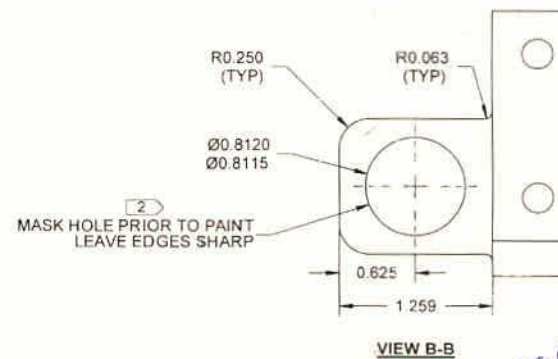
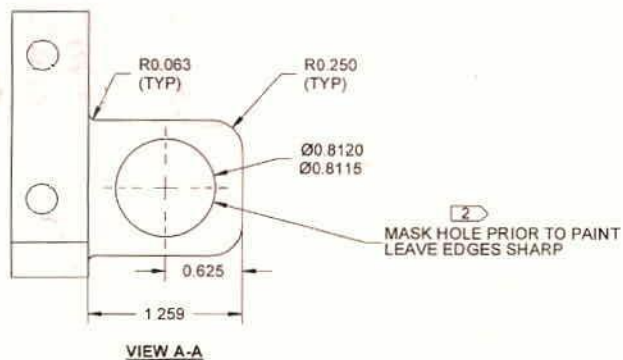
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2616-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs
- 8) D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO ALLOW ROTATION USING DT8019 TOUCH UP PAINT AFTER STAKING.

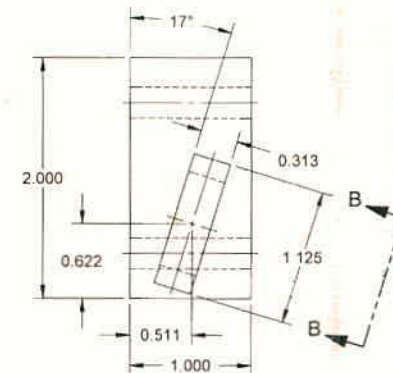
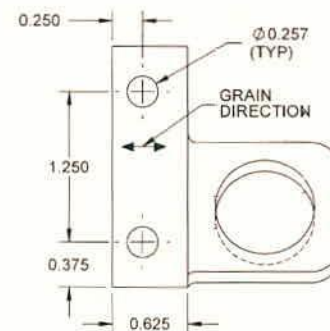
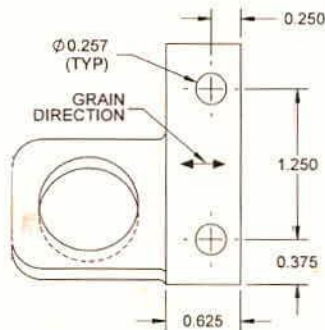
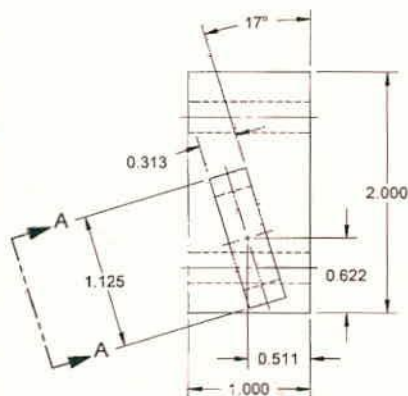
REV.	DESCRIPTION	BY	DATE
E	UPDATE DWG. SHOW 4 STAKES INSTEAD OF 8 INCORPORATE HAND CHANGES	DC	07.11.22
D	D2611 WAS CBA-6-B2	KE	07.07.21
C	REMOVE D2616-3	BW	07.06.04
B	RE-DESIGN	KE	07.05.06
A	ORIGINAL ISSUE	BW	05.10.20
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2616	SHEET 1 OF 2
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	FWD MOUNT LUG	1:1
DATE	07.11.22	<small> COPYRIGHT © 1996 BY DART AEROSPACE LTD. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION FROM DART AEROSPACE LTD. </small>	

RELEASED
07.12.22

#108295



#108295



D2616-1A LUG

D2616-2A LUG

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK BEARING HOLE PRIOR TO PAINT
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED
07-12-12

DESIGN	BW	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.		D2616	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR		FWD MOUNT LUG	1:1
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE EXTERIOR UNDER THE PROVISIONS OF THE NOT TO BE USED FOR ANY PURPOSES OF COPIES OR TRANSMISSION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 108295
Description: MOUNTING LOG		Part Number: D2616-1
Inspection Dwg: D2616 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/- 0.010	0.063	✓		Rad 6	JFC
R0.250	+/- 0.010	0.250	✓		"	"
0.812-0.8115	N/A	0.8118	✓		PIN/TG	JFC-02
0.625	+/- 0.010	0.619	✓		Caliper	JFC-01
1.259	"	1.258	✓		"	"
0.313	"	0.312	✓		"	"
1.125	"	1.125	✓		"	"
2.000	"	2.003	✓		"	"
0.622	"	0.622	✓		"	"
0.511	"	0.511	✓		"	"
1.000	"	1.000	✓		"	"
0.257	-0.001/+0.006	0.257	✓		PIN	JFC
0.250	+/- 0.010	0.249	✓		Caliper	JFC-01
1.250	"	1.247	✓		"	"
0.375	"	0.375	✓		"	"
0.625	"	0.622	✓		"	"

Measured by: JFC	Audited by: <i>amk</i>	Preliminary Approval:
Date: 2013-10-16	Date: 13/10/17	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15